



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2665-1**Job Sheet 186472****Part No:** D2665-1**Job Qty:** 5 ea**Part Name:** Saddle, LH Fwd Aft Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/16/18**Job Tracking No:****Due Date:** 12/14/18**Created By:** Jesse White**Type:** Stock**Description:**

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-1		11/18/18
100	CNC Vertical Machining	5 pcs	12/14/18	12/14/18	1.75	7.69	HAAS1-2		
110	Mill Conv	5 pcs	12/14/18	12/14/18	0.00	5.00	Mill Conv 1		
120	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-1		
130	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	5 pcs	12/14/18	12/14/18	0.00	0.35	HandFinish1		
150	Powdercoat	5 pcs	12/14/18	12/14/18	0.00	0.25	Powdercoat1		
160	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC3		
170	Packaging	5 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		
180	QC21-SA	5 Ea	12/14/18	12/14/18	0.00	0.00	QC21		

Part Op 100 - Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 Descriptions: of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 9:25 OVEN TEMPERATURE: 320° FINISH TIME: 9:55

M 138451

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	5 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	5	59	0

Part Specifications

Specifications could not be found.

Plex 11/16/18 8:43 AM dart.white.jesse



Container No: S128769



Part: D2665-1

Job No: 186472

Serial No/Batch: S128769

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 11/18/18

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.130	0.130	0.130	0.130	0.130
B	0.100	0.140		0.128	0.128	0.1275	0.130	0.130
C	1.125	1.145	/	1.135	1.135	1.135	1.135	1.135
D	0.615	0.685	/	0.665	0.665	0.665	0.665	0.665
E	0.240	0.260		0.260	0.258	0.254	0.254	0.254
F	1.313	1.343	/	1.332	1.332	1.332	1.332	1.332
G	0.210	0.230		0.230	0.224	0.224	0.223	0.224
H	0.100	0.180	/	0.140	0.140	0.140	0.140	0.140
I	2.470	2.510	/	2.500	2.500	2.500	2.500	2.500
J	1.565	1.585	/	1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		0.238	0.237	0.238	0.238	0.238
L	0.100	0.120		0.118	0.118	0.118	0.118	0.118
M	0.990	1.010	/	1.006	1.006	1.006	1.006	1.006
N	0.510	0.515		0.510	0.510	0.510	0.510	0.510
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255	/	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	/	2.500	2.500	2.500	2.500	2.500
R	0.312	0.318	/	0.313	0.313	0.313	0.313	0.313
S	0.315	0.322	/	0.316	0.316	0.316	0.316	0.316
T	2.495	2.505	/	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	/	1.363	1.363	1.363	1.363	1.363
V	0.787	0.807		0.7935	0.7935	0.7943	0.794	0.793
W	0.540	0.560		0.5475	0.550	0.552	0.550	0.551
X	1.674	1.684	/	1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262	/	0.257	0.257	0.257	0.257	0.257
Z	0.912	0.932		0.926	0.924	0.922	0.923	0.921
AA	0.490	0.510		0.4975	0.501	0.503	0.5025	0.5049
AB	0.178	0.198	/	0.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								

Accept/Reject

Measured by: <i>VH8 18/11/18</i>	Date:
Audited by: <i>mm L</i>	Date: 18/11/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	<i>M</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>186472</u> Part No. <u>D2665-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>2018/11/18</u>		Step #: <u>100</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-11-19</u>	
Description Work Order Deviation <u>Ballmill Lin. removed too much material because the offsett was setted too low</u>				Disposition <u>replace and destroy</u>		Completed By 	
						Lead hand / Supervisor Approval Verification <u>B.A 18-11-22</u>	
						QC / QA Coordinator Approval DAS 9 9-89 <u>18-11-19</u>	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☒ Offset/Setup ☒ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ ☒ Off-set Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____							

